

Work Order ID 81042

March-07-12 7:45:17 AM

81042

Page 1

Item ID: D412-698-015

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Door Support

Stop

NS2

Start Date: 07/03/2012 Start Qty: 5.00

5

Cust Item ID:

Required Date: 21/03/2012 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: MLJDate: 12/03/07 Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
IIN D412-698	Rev E

100

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D412-698-015 CHG001

JB

S.7/20/05

110

110

Pick Kit

0.00

Packaging

Memo

0.00

Packaging

JB 12/04/04
SP

120

120

QC4- 100% Inspect kits for completeness

0.00

QC

Memo

0.00

Quality Control

S.7/20/05

(TD)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81042

March-07-12 7:45:17 AM

81042

Page 2

Item ID: D412-698-015

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Door Support

Stop

NS2

Start Date: 07/03/2012 Start Qty: 5.00

5

Cust Item ID:

Required Date: 21/03/2012 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:	Stop		*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Packaging	Packaging	0.00							<i>(5x) SP/2-04-05</i>
Packaging	Memo	0.00							
	Identify and pack for shipping as per PPP D412-698-015								
	Location: _____								
	PPP Rev: <i>B</i>								
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release	0.00							<i>12/4/10 JJ</i>
	Memo	0.00							

*MF
12-04-09*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-07-12 7:45:24 AM

Page 1
Z

Work Order ID: 81042

81042

Parent Item: D412-698-015

D412-698-015

Parent Item Name: Door Support

Start Date: 07/03/2012

Required Date: 21/03/2012

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:C Removed Manufacturing 06-01-25 JLM
IPP Rev:D change to rev D ECN 1104 08-01-28 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960JD10L	NAS1149D0332J	Purchased	No			110	Each	0.0000	12	60	✓		

AN960.ID10I	**	120644	JB	ZP
---------------	----	--------	----	----

Washer	2	10	✓	
--------	---	----	---	--

D3200-1	**	5+79034	JB	ZP
---------	----	---------	----	----

Location

ST033 5

68969 5

110 Each 10.0000

2 10 ✓

**

5+768969

✓

JB ZP

Location

ST033 10

76214 10

110 Each 2.0000

2 10 ✓

76214

✓

JB 12/01/04

ZP

Location

ST033 2

68968 1

71597 1

✓

X 71597

D3200-3	**	9X 79035	JB	12/01/04
---------	----	----------	----	----------

Door Wedge	2	10	✓	
------------	---	----	---	--

D3201-1	**	9X 79035	JB	12/01/04
---------	----	----------	----	----------

Doubler	2	10	✓	
---------	---	----	---	--

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-07-12 7:45:24 AM

Page 2

Work Order ID: 81042

81042
D412-698-015

Parent Item: D412-698-015
Parent Item Name: Door Support

Start Date: 07/03/2012

Required Date: 21/03/2012

Start Qty: 5.00

Required Qty: 5.00

D3201-3

S
D3201-3
Doubler

Manufactured No

110 Each 27.0000

1 5
**

✓
JB SP

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST033

27

71661

27

Manufactured No

110 Each 9.0000

1 5
**

✓
JB SP

D3201-4

S
D3201-4
Doubler

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST033

9

69026

9

Purchased No

110 Each 3,552.000

12 60
**

✓
JB SP

MS21042L3

S
MS210421 3
Nut

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST300

3552

117441

16

117885

32

118451

5

118927

3

119017

3316

119075

180

119017

Purchased No

110 Each 55.0000

12 60
**

✓
6x 120986 JB 12/04/04

MS24693-S277

S
MS24693-S277
Screw

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST288

55

117591

1

119819

54

54x119819

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

7.0 PARTS LIST - PILOT DOOR MODIFICATION KITS

Qty 015	Qty -023	Part Number	Description
X		D412-698-015	DOOR SUPPORT KIT
	X	D412-698-023	AUTOMATIC DOOR OPENER KIT
2		D3200-1	DOOR POST BLOCK
2		D3200-3	DOOR WEDGE
2		D3201-1	DOUBLER
1		D3201-3	ANGLE
1		D3201-4	ANGLE
	1	D3552-11	GAS SPRING
	1	D3594-5	DOOR DOUBLER
	1	D3594-043	FLOOR DOUBLER ASSEMBLY, LH
	1	D3594-044	FLOOR DOUBLER ASSEMBLY, RH
	2	D3622-1	BALL STUD
	1	MS21073L5	ANCHOR NUT
	2	MS20426AD4-4	RIVET
12		AN960JD10L	WASHER
	2	AN960JD516L	WASHER
12		MS21042L3	NUT (OR MS21042-3)
12		MS24693-S277	SCREW

Work Order ID 81042

March-07-12 7:45:17 AM

81042

Page 1

Item ID: D412-698-015

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Door Support

Start Date: 07/03/2012 Start Qty: 5.00

5

Cust Item ID:

Required Date: 21/03/2012 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/03/07 Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

IIN D412-698	Rev E	0.00							MLJ 12/04/04
100 *100* DC	DOCUMENT CONTROL Memo Document Control	0.00							(5)
110 *110* Packaging Packaging	Pick Kit Memo	0.00							
120 *120* QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00							